

Work Order ID 53319

October 30, 2009 10:17:40 AM



Page 1

Item ID:	D3281-3	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Floor Protector, Aft LH					
Start Date:	30/10/2009	Start Qty:	10.00		Cust Item ID:	
Required Date:	16/11/2009	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	09-10-30	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	Draw Nbr	Revision Nbr							
	D3281	Rev D							
100		0.00							
	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								
110		0.00							
	THERMOFORMING MACHINE								
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3281 and Folio FTA 009 <input type="checkbox"/> Dwg. Rev. <input checked="" type="checkbox"/> Folio Rev.								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

BB
09/11/03
X10

BB
09/11/04
X10

BB
09/11/04
X10

Work Order ID 53319

October 30, 2009 10:17:40 AM



Page 2

Item ID: D3281-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Floor Protector, Aft LH

Start Date: 30/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop





Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00							
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

PTO
Wh. 09/11/04 →
(x10)

Wh. 09/11/05
(x10)

→ 802/11/07

(x10)

W/O: 53319		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.11.09	130	PARTS CUT FLAT @ 0.95" HIGH				 09.11.09 PC 081042	 07/11/27

Part No: D 3281-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53319

October 30, 2009 10:17:40 AM



Page 3

Item ID: D3281-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Floor Protector, Aft LH

Start Date: 30/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Packaging

0.00

Memo

0.00

Packaging

09/11/26 [Signature]

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

09/11/26 [Signature]
R09-11-20

Picklist Print

October 30, 2009 10:17:45 AM

Page 1

Work Order ID: 53319



Parent Item: D3281-3RevD



Parent Item Name: Floor Protector, Aft LH

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No			100	sf	1,550.250	43.3300			

GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1550.25

106751

6.26

110877

1543.99

BB
09/11/03
(X10)

DART AEROSPACE LTD		Work Order:	53319
Description: Floor Protector, Aft LH		Part Number:	D3281-3
Inspection Dwg: D3281	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

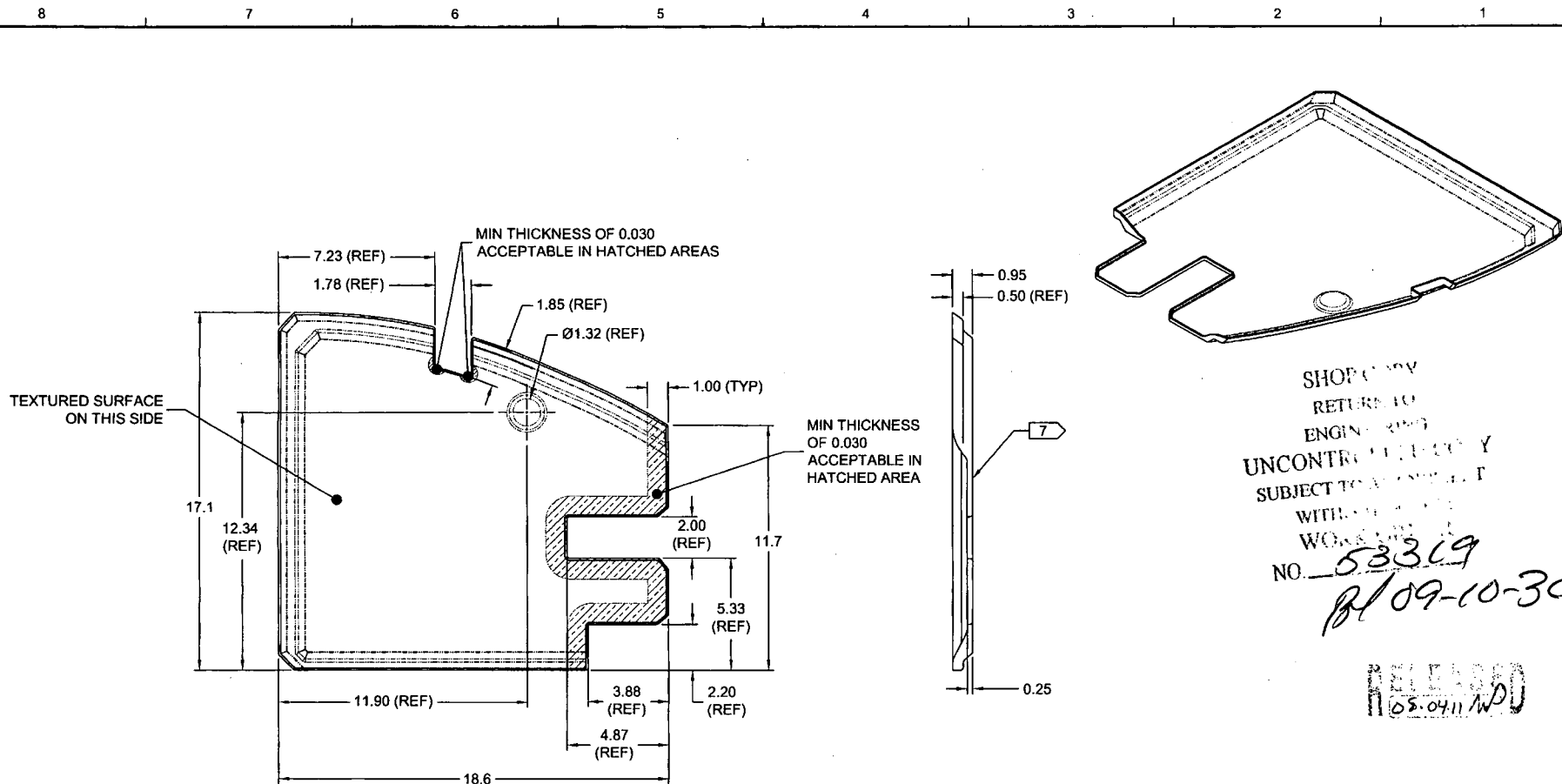
Measured by:	Wh	Date:	09/11/03
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.7	✓			
17.1	+/-0.100	17.0	✓			
14.3	+/-0.100	14.25	✓			
0.95	+/-0.030	0.98	✓			
0.25	+/-0.030	N/A				
3.1	+/-0.100	3.125	✓			
0.050	Min	0.065	✓			
0.070	Min	0.75				

Measured by:	Wh	Date:	09/11/05
Audited by:	S	Date:	02/4/17
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	



D3281-1 FLOOR PROTECTOR

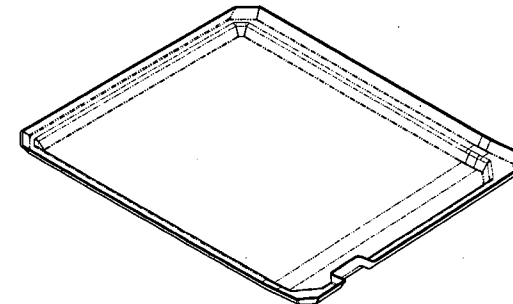
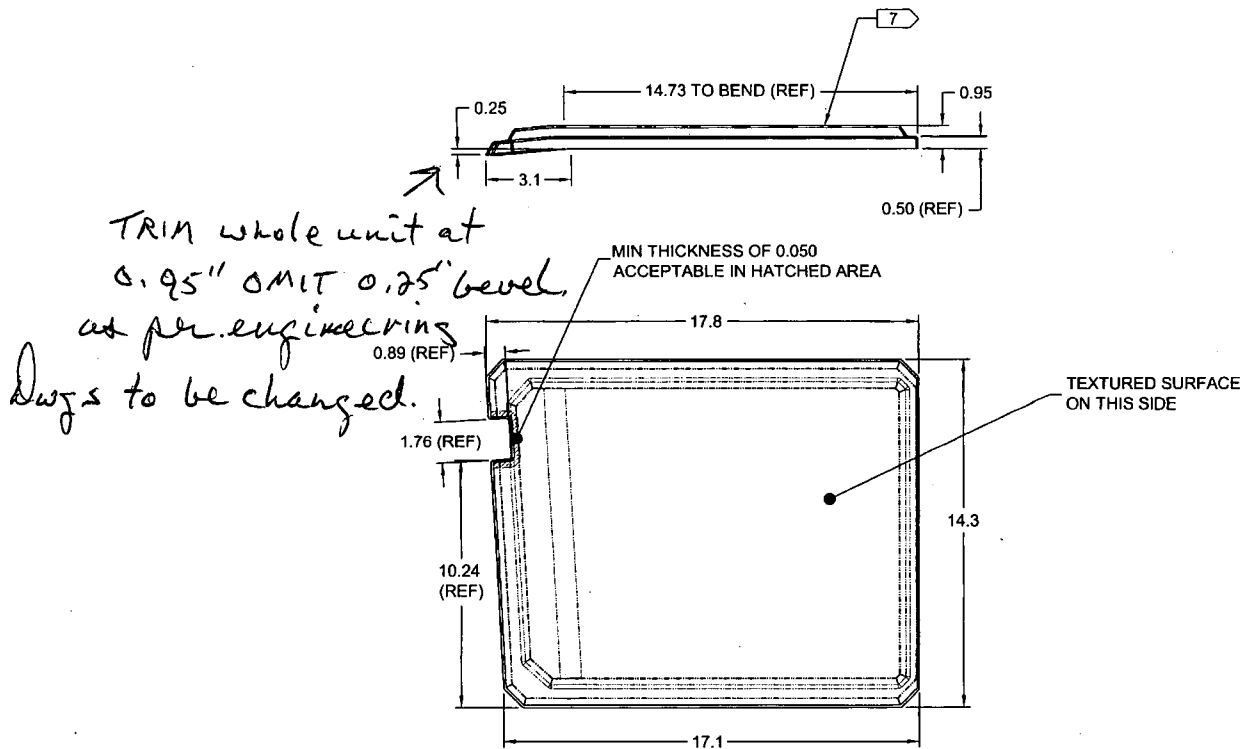
D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb

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NO. 53369
B/09-10-30

RELEASED
11-03-04 11 WDU

D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	40	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RA		
CHECKED	13	DRAWING NO.	REV. D
MFG. APPR.	RA	D3281	SHEET 1 OF 4
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DE APPR.	4	FLOOR PROTECTOR	NTS
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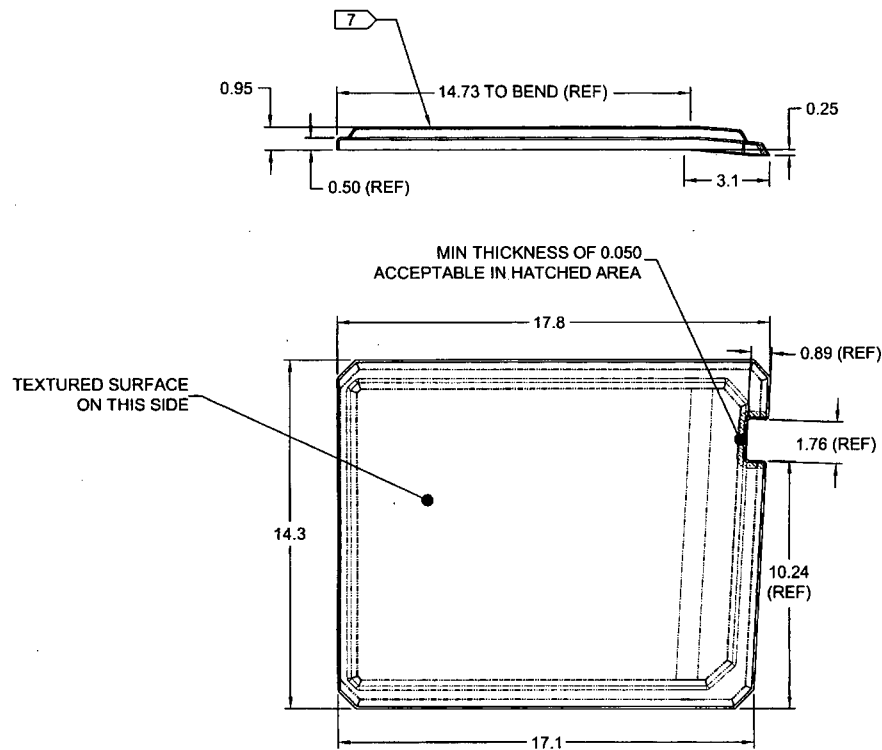
D3281-3 FLOOR PROTECTOR

D3281-3 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	92	DART AEROSPACE LTD	
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MFG. APPR.	50	D3281	SHEET 3 OF 4
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DE APPR.	WJ	FLOOR PROTECTOR	NTS
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D3281-4 FLOOR PROTECTOR

D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No: 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

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APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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